

Claims.

5 1.- Method for manufacturing visual communication panels of the type which mainly consists of a support (2), provided on at least one side with a coating (11) made of enamelled metal, glazed at temperatures above 500°C, characterised in that it mainly consists in applying a continuous coating  
10 layer (11) of enamelled metal on at least one side of a continuous support (2) in the form of a plate; in gluing the coating layer (11) on the support (2); in pressing the coating layer (11) against the support (2) to form a continuous panel with the required thickness; and finally,  
15 optionally, in sawing the obtained continuous panel into individual panels (25) with the required dimensions.

2.- Method according to claim 1, characterised in that the continuous support is provided with a continuous coating  
20 layer on either side, (11) and (28) respectively, of which at least one coating layer (11) is formed of enamelled metal, glazed at temperatures above 500°C.

3.- Method according to claim 1 or 2, characterised in  
25 that, for pressing on the coating layer or layers (11-28), the support (2) is synchronously led through a laminating device (3) together with the coating layer or layers (11-28), whereby the continuous coating layer or layers (11-28) are each unwound from a roll (10-27).

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4.- Method according to any of the preceding claims, characterised in that the coating layer or layers (11-28) are heated before being led into the above-mentioned laminating device (3).

5.- Method according to any of the preceding claims, characterised in that between the support (2) and the coating layer (11), layers (11-28) respectively, is provided a layer of glue (26).

6.- Method according to claim 5, characterised in that the layer of glue (26) consists of a cold glue.

7.- Method according to any of claims 1 to 5, characterised in that the layer of glue (26) consists of a hot glue which melts under the influence of heat and congeals again when cooled.

8.- Method according to claim 7, characterised in that the layer of glue (26) is based on a hot glue in the shape of what is called a "hot-melt adhesive".

9.- Method according to claim 7, characterised in that the layer of glue (26) consists of polymers in the shape of hot-melt adhesive granules or powders.

10.- Method according to claim 7, characterised in that the support (2) and the coating layer or layers (11-28) in the laminating device (3) are subsequently heated and cooled again.

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11.- Method according to any of the preceding claims, characterised in that the layer of glue (26) is formed of an adhesive film (19-30) wound on a roll (18-29) and which is fed through the above-mentioned laminating device (3) as  
5 of this roll (18-29) together with and between the support (2) and the coating layer or layers (11-28) concerned.

12.- Method according to claim 11, characterised in that the above-mentioned layer of glue (26) is provided on the  
10 support (2) and/or on the coating layer or layers (11-28).

13.- Method according to claim 5, characterised in that the layer of glue (26) is obtained from adhesive granules (43) which are extruded to form an adhesive film.

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14.- Method according to claim 5, characterised in that the layer of glue (26) is provided by means of spraying, curtain coating, roller coating, silkscreen printing, stencilling or powdering.

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15.- Method according to claim 14, characterised in that the support (2), when being supplied, is already provided with a layer of glue, or in that the material of the supplied support comprises gluing components or has gluing  
25 properties.

16.- Device for manufacturing visual communication panels (25) according to the method of one or several of the preceding claims, characterised in that it mainly consists  
30 of a transport table (1) for a continuous support (2); at least one roll (10) of a continuous coating layer (11)

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which is formed of a continuous layer of enamelled metal; a laminating device (3) through which the above-mentioned support (2) and the coating layer (11) are led; means (17) for gluing the coating layer (11) to the support (2); and  
5 possibly a sawing device (23-24) downstream of the laminating device (3).

17.- Device according to claim 16, characterised in that it is provided with two rolls (10-27) of a coating layer, (11)  
10 and (28) respectively, of which at least one coating layer (11) is formed of an enamelled metal, whereby the support (2) is led through the laminating device between the coating layers (11-28) and whereby means (17) are provided to apply a layer of glue (26) between the support and both  
15 coating layers (11-28).

18.- Device according to claim 16 or 17, characterised in that it is equipped with one or several heating appliances (16) which are provided opposite to the coating layer or  
20 layers (11-28); in particular between the above-mentioned roll or rolls (10-27) and the laminating device (3).

19.- Device according to any of claims 16 to 18, characterised in that the laminating device (3) is formed  
25 of a table (1) and an endless belt (4) opposite to said table 1, and of two endless belts (4) erected opposite to one another, whereby the laminating device (4) is provided with heating elements (6) and with cooling elements (8).

30 20.- Device according to claim 16 or 17, characterised in that the means (17) for providing a layer of glue (26)

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consist of one or two rolls (18-29) with an adhesive film (19-30), whereby each adhesive film (19-30) is lead through the laminating device (3) between the support (2) and a coating layer (11-28) concerned.

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21.- Device according to claim 16 or 17, characterised in that the means (17) for applying a layer of glue (26) are formed of one or several extruding applications (39) which are fed with adhesive granules (43).

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22.- Device according to claim 16 or 17, characterised in that the means (17) for applying a layer of glue (26) consist of one or several appliances (44) for spraying, curtain coating, roller coating, silkscreen printing, stencilling or scattering glue (45).

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